

Work Order ID 81961

81961

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March-21-12 1:43:24 PM

Item ID: D3692-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: SPACER

Start Date: 21/03/2012 Start Qty: 200.00

200

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 200.00

200

Customer:

Reference:

Approvals: Process Plan: MLJDate: 12/03/21 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3692	Rev B								

100

0.00

100

DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1- Turn as per Folio FA725 Rev: & Dwg D3692 Rev: 2-Deburr
per dwg D3692

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

200 0200 0200 0 36
12/03/1212/4/3012/4/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81961

81961

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March-21-12 1:43:24 PM

Item ID: D3692-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: SPACER
 Start Date: 21/03/2012 Start Qty: 200.00 ***200*** Cust Item ID:
 Required Date: 04/04/2012 Req'd Qty: 200.00 ***200*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>661</u>	0.00							
130									
Packaging	Memo	0.00				200			6/5/30
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							12/5/17
Quality Control									

12-05-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 81961

81961

Parent Item: D3692-1

D3692-1

Parent Item Name: SPACER

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP Rev:A New Issue 08-02-15 JLM Verified By:EC
IPP Rev:B As per Rev B 09-01-20 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M303R0.500

Purchased

No

100

f

263.2350

0.0305

6.421053

M303R0 500

303 Round Bar 0.500"

**

SA 12/4/30

Location

Loc Qty

Loc Code

MAT028

263.235

117143

11.34

1 X 118271

11.9

2 X 118509

2.36

2 X 119009

140.088

3 X 119616

97.547

2-377

2-411

8.21
2.511

5-8-

611

1 32 inches

2 10 inches

3 4 inch

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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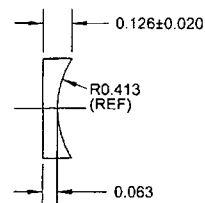
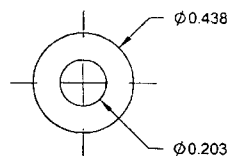
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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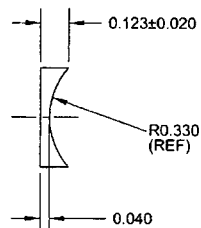
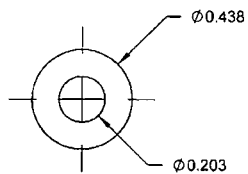
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. B1961 MJS

12/03/



D3692-1 SPACER



D3692-3 SPACER

NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR (REF. DART SPEC. M303R) OR AISI 304/316 STAINLESS STEEL ROUND BAR (REF. DART SPEC. M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.003 lb

RELEASED
09/01/15

B	REMOVED SHADED VIEW (ZN C2-1, D2-1); REFORMATTED SHEET	RF	08.12.15
A	NEW ISSUE	RF	08.03.12
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3692	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		SPACER	NTS
DATE	08.12.15	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT PERMISSION FROM DART AEROSPACE LTD.	

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